






Punches, Dies, and Draw Studs

⚠ WARNING READ ALL SAFETY WARNINGS AND ALL INSTRUCTIONS. Failure to follow the warnings and instructions may result in electric shock, fire and/or serious injury. **Save all warnings and instructions for future reference.** Before using the Punch, Die and Draw Stud, read this instruction sheet, your tool's operator's manual, and all labels on the tool.

- **Keep work area clean and well lit.** Cluttered or dark areas invite accidents.
- **Do not overreach. Keep proper footing and balance at all times.** This enables better control of the power tool in unexpected situations.
- **Dress properly. Do not wear loose clothing or jewellery. Keep your hair, clothing and gloves away from moving parts.** Loose clothes, jewellery or long hair can be caught in moving parts.
- **Use tool only as directed. Only trained personnel should operate tool.**
- **Do not use in or near live electrical panels.** Only work on de-energized electrical panels. Disconnect all electrical current before use to avoid the risk of electric shock.
- **Keep hands away from knockout die and punch while tool is in use.** Fingers could be crushed or severed.
- **To reduce the risk of injury, wear safety goggles or glasses with side shields. Before use, inspect and discard workpieces and accessories with cracks or damage.** Shards from weakened metal could cause injury.
- **Avoid contact with punched metal edges.** Edges may be sharp and could cause injury.
- **Do not attempt to punch through more than one layer of material at a time.** Punching through multiple layers could cause the material and accessories to warp break, throwing shards that could cause injury.
- **Use tool only with knockout dies and punches rated for the peak output force of the tool. Ensure all threads are hand-tightened securely before operating.** Other uses may cause injury or damage to the tool, accessories, and workpiece.

SYMBOLOLOGY

| | |
|---|---|
|  | WARNING Risk of electric shock. Do not use in or near live electrical panels. |
|  | Always wear eye protection |
|  | WARNING Keep hands away from punch and die. Fingers could be crushed or severed. |

| Conduit Size | Nominal Hole Size | Die Part Number | Punch Part Number | Draw Stud Part Number <i>For use in 10 ga Mild Steel 12 ga Stainless Steel</i> | Thrust Bearing Draw Stud Part Number <i>For use in 10 ga Mild Steel</i> | Pilot Hole Diameter | Grease |
|--------------|---------------------|-------------------|-------------------|---|--|---------------------|---------------|
| 1/2" | 7/8" (22.2 mm) | 1/2" 49-16-2660 | 1/2" 49-16-2661 | -- | 3/8" 49-16-2621 | 7/16" (11 mm) | ** |
| 1/2" | 7/8" (22.2 mm) | 1/2" 49-16-2660S | 1/2" 49-16-2661S | 7/16" 49-16-2680 | -- | 1/2" (13 mm) | -- |
| 3/4" | 1-7/64" (28.2 mm) | 3/4" 49-16-2662 | 3/4" 49-16-2663 | 3/4" 49-16-2681 | 3/4" 49-16-2622 | 7/8" (22 mm) | ** |
| 1" | 1-3/8" (34.9 mm) | 1" 49-16-2664 | 1" 49-16-2665 | 3/4" 49-16-2681 | 3/4" 49-16-2622 | 7/8" (22 mm) | ** |
| 1-1/4" | 1-47/64" (44 mm) | 1-1/4" 49-16-2666 | 1-1/4" 49-16-2667 | 3/4" 49-16-2681 | 3/4" 49-16-2622 | 7/8" (22 mm) | ** |
| 1-1/2" | 1-63/64" (50.4 mm) | 1-1/2" 49-16-2668 | 1-1/2" 49-16-2669 | 3/4" 49-16-2681 | 3/4" 49-16-2622 | 7/8" (22 mm) | S2 49-08-5262 |
| 2" | 2-15/32" (62.7 mm) | 2" 49-16-2670 | 2" 49-16-2671 | 3/4" 49-16-2681 | 3/4" 49-16-2622 | 7/8" (22 mm) | S2 49-08-5262 |
| 2-1/2" | 2-31/32" (75.4 mm) | 2-1/2" 49-16-2672 | 2-1/2" 49-16-2673 | 1-1/8" 49-16-2682 | -- | 1-1/4" (32 mm) | -- |
| 3" | 3-19/32" (91.3 mm) | 3" 49-16-2674 | 3" 49-16-2675 | 1-1/8" 49-16-2682 | -- | 1-1/4" (32 mm) | -- |
| 3-1/2" | 4-1/8" (104.8 mm) | 3-1/2" 49-16-2676 | 3-1/2" 49-16-2677 | 1-1/8" 49-16-2682 | -- | 1-1/4" (32 mm) | -- |
| 4" | 4-41/64" (117.9 mm) | 4" 49-16-2678 | 4" 49-16-2679 | 1-1/8" 49-16-2682 | -- | 1-1/4" (32 mm) | -- |

** It is recommended to use Grease S2 49-08-5262 on all draw stud threads before beginning a punch

MILWAUKEE ELECTRIC TOOL CORPORATION
13135 West Lisbon Road • Brookfield, Wisconsin, U.S.A. 53005
12/13